

Work Order ID 120644

June-09-14 2:37:51 PM

120644

Item ID: D3537-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 6/09/14

Start Qty: 60.00

60

Cust Item ID:

Required Date: 6/20/14

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 24577
CUT PER DRWG D3537 REV.C

CL 14/100/12 60

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

P 14/7/4 (60)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/7/8

60
can

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Page 2

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Stop ***NS2***

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60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2-
Identify as D3537-1

0.00

0.00

DAS
30
9-89

60

14/07/08

140

140

Large Fab

Large Fab

Large Fab

Memo

Qty Description Batch A/R 2059B Hardcoat
m129694 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any
weld that penetrated through Wearpad if necessary

0.00

0.00

60

14-08-21
jbr

150

150

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

DAS
50
9-89

60

14-8-21

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June-09-14 2:37:51 PM

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N900040100

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NS1

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Stop

NS2

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Start Date: 6/09/14

Start Qty: 60.00

60

Cust Item ID:

Required Date: 6/20/14

Req'd Qty: 60.00

60

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

60

14821

DAS
50
9-89

170

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:25

OVEN TEMPERATURE:

FINISH TIME:

7:55

60

14-8-22

DAS 34 9-89

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

60

2P

14/08/22

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 6/09/14 Start Qty: 60.00

60

Cust Item ID:

Required Date: 6/20/14 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

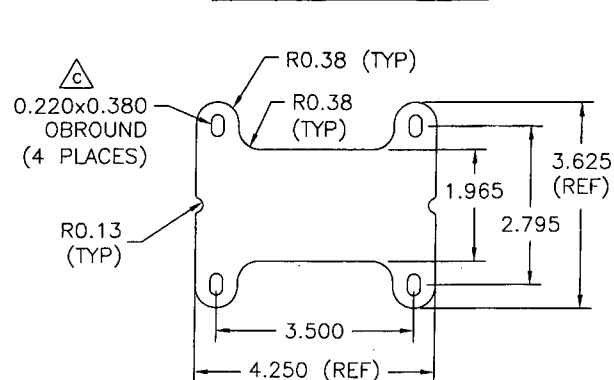
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>EP-001</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

x60 d ll 1.168/25

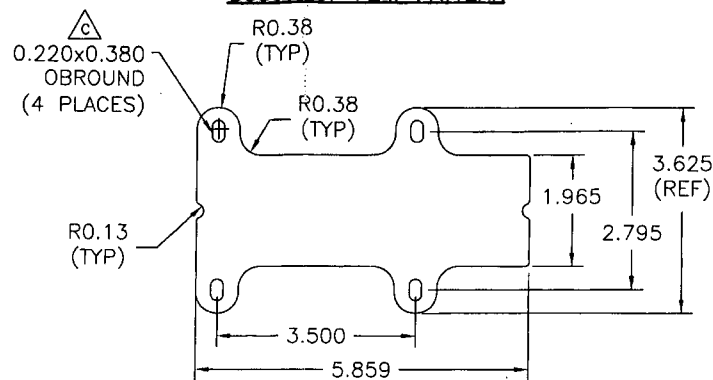
MLJ 14-08-25

ATK 8.25

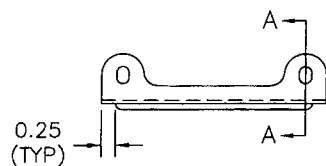
D3537-1F FLAT PATTERN



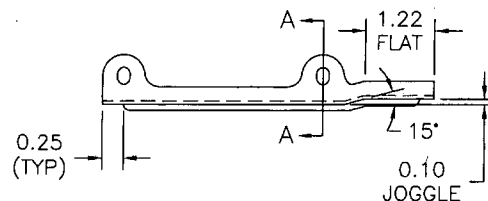
D3537-3F FLAT PATTERN



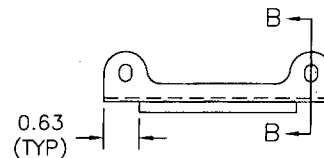
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



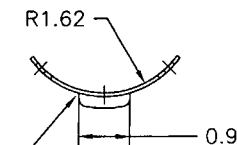
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

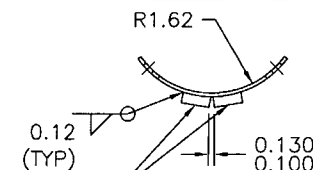


SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

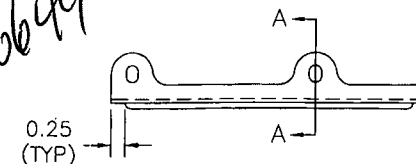
SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
02-05-08 AB
PER ECA
962

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
CHECKED	B	07.03.20	ADD AMS 5513 AND AMS 5524
APPROVED	A	06.11.06	NEW ISSUE
DRAWN BY	CB	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
TITLE	WEARPAD	DRAWING NO.	D3537
DATE	07.04.13	REV. C	SHEET 1 OF 1
		SCALE	1:2

W/O 120644

OK 11/1/15

UNDER REVIEW
11/1/15
Twins
Change

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6177
Date: 2014-07-02
Page: 1

Sold to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Ship to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24577	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-02
Tracking No.:	

Item No.	Unit	Description	Quantity
d3564-5	Chaque	d3564-5	24
d3564-9	Chaque	d3564-9	24
d3564-11	Chaque	d3564-11	24
d3791-1	Chaque	d3791-1 wearpad	24
d3537-3	Chaque	d3537-3 wearpad	24
d3537-1	Chaque	d3537-1 wearpad	40
d3537-1	Chaque	d3537-1 wearpad	60
d3791-1	Chaque	d3791-1 wearpad	60
d2154	Chaque	d2154 bracket stud	20
d2144	Chaque	d2144 hinge doubler	40
d4095-045	Chaque	d4095-045 wearplate assy	40
d4095-043	Chaque	d4095-043	12
d4095-041	Chaque	d4095-041 wearplate assy	12
d3859-041	Chaque	d3859-041 wearplate	12
d4952-1	Chaque	d4952-1 wearplate	16
d4095-051	Chaque	d4095-051 wearplate assy	20
d4095-049	Chaque	d4095-049 wearpad	20
d4095-047	Chaque	d4095-047 wearplate assy	16
d4798-041	Chaque	d4798-041 wearplate assy	20
d4135-1	Chaque	d4135-1 wearpad	16
d4360-041	Chaque	d4360-041 wearplate assy	10
d2012-111	Chaque	d2012-111 bracket	8
d2324-5	Chaque	d2324-5 strap	40
d2947	Chaque	d2947 clamp	40
d3171-1	Chaque	d3171-1 angle bracket	60
d3463-3	Chaque	d3463-3 step	20
d3512-1	Chaque	d3512-1 wearplate	12
d3629-1	Chaque	d3629-1 bracket	16
d3955-5	Chaque	d3955-5 plate	20
d4021-5	Chaque	d4021-5 blanking plate	12
d3556-1	Chaque	d3556-1 clamp	40

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days

